

Date: Monday, 18/08/2008 3:38:05 PM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	HELI-UTILITY BASKET RH
Job Number :	41327		
Estimate Number :	12433		
P.O. Number :		Part Number :	D205541044
This Issue :	18/08/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	IIN D205-541 REV G
First Issue :	/ /	Project Number :	
Previous Run :	40180	Drawing Revision :	G
Written By :		Material :	
Checked & Approved By :	JUD 08.8.18	Due Date :	15/09/2008
Comment :	Est Rev:C Re-Format 02-08-30 KJ Est Rev:D chg to revG Ecn 1157 08-03-19 DD verified by:		

Qty: 1 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0

DC

DOCUMENT CONTROL



08/09/16

JUD 08.9.11



Comment: Photocopy bluefile & type labels per PPPD205-541-044 CHG002

2.0

41327A

350/212/130 BASKET LID



Comment: Sub-Component 350/212/130 BASKET LID
 1 x D2512 Batch 41327A

3.0

41327B

212 BASKET BASE ASS'Y RH



Comment: Sub-Component 212 BASKET BASE ASS'Y RH
 1 x D3053-042 Batch 41327B

4.0

D2022101

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Spacer
 Batch: 39880

5.0

D2258300

Label



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Placard
 Batch: 37538

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 18/08/2008 3:38:05 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-UTILITY BASKET RH

Job Number: 41327

Part Number: D205541044

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2332041

Lid Prop Assembly 6.69" long



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Lid Prop Assembly 6.69"

Batch:

39332

JS 08/09/12 (K)

7.0

D2530

Handle Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Handle Weldment

Batch:

B40211

JS 08/09/15

8.0

D2535

Spring



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Spring

Batch:

39670

JS 08/09/12 (K)

9.0

D2537

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bushing

Batch:

39153

JS 08/09/12 (K)

10.0

D2931

Bumper



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bumper

Batch:

21139

JS 08/09/12 (K)

11.0

AN316A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bolt

Batch:

107737

JS 08/09/12 (K)

12.0

AN47A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bolt

Batch:

108077

JS 08/09/12 (K)

W/O:		WORK ORDER CHANGES					
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Drawing Name: HELI-UTILITY BASKET RH

Job Number: 41327

Part Number: D205541044

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

AN422A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Bolt

Batch: M107715

JS 08/09/12 (X)

14.0

AN424A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Bolt

Batch: 104547

JS 08/09/12 (X)

15.0

AN517A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

Batch: M108558

JS 08/09/12 (X)

16.0

AN960JD416

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Washer

Batch: M108553 M108161

JS 08/09/12 (X)

17.0

AN960JD416L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Washer

Batch: M108583

JS 08/09/12 (X)

18.0

AN960JD516

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Washer

Batch: 108672

JS 08/09/12 (X)

19.0

AN960JD8

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Washer

Batch: M108335

JS 08/09/12 (X)

Dart Aerospace Ltd

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Job Number: 41327

Part Number: D205541044

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

AN9704

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Batch:

M108928

JS 08/09/12 @

21.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch:

M108701

JS 08/09/12 @

22.0

MS21042L4

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch:

M107499

JS 08/09/12 @

23.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch:

M108161

JS 08/09/12 @

24.0

MS20600AD4W3

Cherry Rivets



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Cherry Rivets

Batch:

18071

JS 08/09/12 @

25.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg.

JS 08/09/16 @

26.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

JS 08/09/16 @

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Drawing Name: HELI-UTILITY BASKET RH

Job Number: 41327

Part Number: D205541044

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

28.0

D21991

Strut Details



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Struts, 19"

Batch: 38453

SS 08/09/12 (X)

29.0

D219923

Strut Details



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Strut

Batch: 40195

SS 08/09/12 (X)

30.0

D219925

Strut Details



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Strut

Batch: 38454

SS 08/09/12 (X)

31.0

D2498

Mounting Bracket, 205 Basket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Mounting Bracket

Batch: 37542

SS 08/09/12 (X)

32.0

D2499

Mounting Bracket, 205 Basket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Mounting Bracket

Batch: 37543

SS 08/09/12 (X)

33.0

D2515

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bushing

Batch: 29138

SS 08/09/12 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-UTILITY BASKET RH

Job Number: 41327

Part Number: D205541044

Job Number:



Seq. #:

Machine Or Operation:

Description :

34.0

D30521

Mounting Lug



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Mounting Lug

Batch: 28522

AS 08/09/12 (X)

35.0

AN47A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: 108072

AS 08/09/12 (X)

36.0

AN412A

Bolt



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Bolt

Batch: 105143

AS 08/09/12 (X)

37.0

AN413A

Bolt



Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)

Bolt

Batch: 109059

AS 08/09/12 (X)

38.0

AN414A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M107534

AS 08/09/12 (X)

39.0

AN57A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Batch: M107378

AS 08/09/12 (X)

40.0

AN513A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Batch: M108167

AS 08/09/12 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-UTILITY BASKET RH

Job Number: 41327

Part Number: D205541044

Job Number:



Seq. #:

Machine Or Operation:

Description :

41.0

AN960JD416

Washer



Comment: Qty.: 29.0000 Each(s)/Unit Total: 29.0000 Each(s)

Washer

M108161

SS 08/09/12 (X)

42.0

AN960JD516

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)

Washer

Batch:

108672

SS 08/09/12 (X)

43.0

MS21042L4

Nut



Comment: Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s)

Nut

Batch:

M07499

SS 08/09/12 (X)

44.0

MS21042L5

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Nut

Batch:

M108161

SS 08/09/12 (X)

45.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

S 08/09/12 (X)

46.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-541-044

Location: BR

PPP Rev: F

8/9/16

SL

(X)

47.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/16 (X)

Job Completion



MF 08-09-16

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

5.0 PARTS LIST HELI-UTILITY-BASKET™

Qty -043	Qty -044	Qty -045	Qty -046	Part Number	Description
X				D205-541-043	HELI-UTILITY-BASKET, LH
	X			D205-541-044	HELI-UTILITY-BASKET, RH
		X		D205-541-045	HELI-UTILITY-BASKET, LH
			X	D205-541-046	HELI UTILITY-BASKET, RH
2*	2*			D2022-101	SPACER
1	1	1	1	D2199-1	STRUT
1	1	1	1	D2199-23	STRUT
1	1	1	1	D2199-25	STRUT
1*	1*	1*	1*	D2258-300	LABEL
1*	1*	1*	1*	D2332-041	PROP ASSEMBLY
1	1	1	1	D2498	MOUNTING LUG
1	1	1	1	D2499	MOUNTING LUG
1*	1*			D2512	BASKET LID ASSEMBLY
2	2	2	2	D2515	BUSHING
1*	1*	1*	1*	D2530	HANDLE ASSEMBLY
2*	2*	2*	2*	D2535	SPRING
2*	2*	2*	2*	D2537	BUSHING
2*	2*			D2931	BUMPER
1	1	1	1	D3052-1	MOUNTING LUG
1*				D3053-041	BASKET BASE ASSEMBLY, LH
	1*			D3053-042	BASKET BASE ASSEMBLY, RH
		1*		D3712-041	BASKET BASE
			1*	D3712-042	BASKET BASE
		1*		D3713-041	LID ASSEMBLY
			1*	D3713-042	LID ASSEMBLY
		6*	6*	D3723-1	BUSHING
2*	2*	2*	2*	AN3-16A	BOLT
2*	2*			AN4-7A	BOLT
2	2	2	2	AN4-7A	BOLT
3	3	3	3	AN4-12A	BOLT
9	9	9	9	AN4-13A	BOLT
2	2	2	2	AN4-14A	BOLT
		3*	3*	AN4-20A	BOLT
1*	1*	1*	1*	AN4-22A	BOLT
1*	1*	1*	1*	AN4-24A	BOLT
1	1	1	1	AN5-7A	BOLT
1	1	1	1	AN5-13A	BOLT
4*	4*	4*	4*	AN5-17A	BOLT
2*	2*	6*	6*	AN960JD416	WASHER
27	27	27	27	AN960JD416	WASHER
2*	2*	2*	2*	AN960JD416L	WASHER
4*	4*	4*	4*	AN960JD516	WASHER
3	3	3	3	AN960JD516	WASHER
2	2			AN960JD8	WASHER
4*	4*	4*	4*	AN970-4	WASHER

...CONTINUED ON NEXT PAGE

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UNCONTROLLED COPY

Revision: G SUBJECT TO AMENDMENT
Date: 08.03.04 WITHOUT NOTICE

WORK ORDER

NO. 41327

...CONTINUED FROM PREVIOUS PAGE

Qty -043	Qty -044	Qty -045	Qty -046	Part Number	Description
2*	2*			MS20600AD4W3	RIVET
2*	2*	2*	2*	MS21042L3	NUT (OR MS21042-3)
4*	4*	5*	5*	MS21042L4	NUT (OR MS21042-4)
16	16	16	16	MS21042L4	NUT (OR MS21042-4)
4*	4*	4*	4*	MS21042L5	NUT (OR MS21042-5)
2	2	2	2	MS21042L5	NUT (OR MS21042-5)

* = ASSEMBLED AT DART

6.0 PARTS LIST HELI-ACCESS-STEP™

Qty -047	Qty -048	Part Number	Description
X		D205-541-047	HELI-ACCESS-STEP, LH
	X	D205-541-048	HELI-ACCESS-STEP, RH
1		D3724-041	STEP ASSY, LH
	1	D3724-042	STEP ASSY, RH
2	2	D3731-1	PLATE
2	2	D3751-1	SHIM
6	6	AN4-13A	BOLT
6	6	AN4-14A	BOLT
24	24	AN960JD416	WASHER
12	12	MS21042L4	NUT (OR MS21042-4)

7.0 OPTIONAL EQUIPMENT

Qty -049	Part Number	Description
X	D205-541-049	LINER KIT
1	D2446	SIGN PLATE
1	D2509	LINER (BASE)
1	D2511	LINER (END)
6	MS24693S272	SCREW
6	A3235-020-935	WASHER
6	NAS679A3W	NUT
4	MS20470AD4-8	RIVET
42	MS20600AD4W4	RIVET

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UNCONTROLLED COPY
SUBJECT TO AMENDMENTRevision: G
Date: 08.03.04WITHOUT NOTICE
WORK ORDER

NO. 91327

Date: Monday, 18/08/2008 3:38:14 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 350/212/130 BASKET LID
Job Number	: 41327A		
Estimate Number	: 10193		
P.O. Number	:	Part Number	: D2512 <i>pt 08.08.19</i>
This Issue	: 18/08/2008 S.O. No. :	Drawing Number	: D2512-UNDER REVIEW
Prsht Rev.	: NC	Project Number	:
First Issue	: / / Type : LARGE FAB ASSY	Drawing Revision	: D2
Previous Run	: 41260A	Material	:
Written By	:	Due Date	: 15/09/2008 Qty: 1 Um: Each
Checked & Approved By	: <i>JL 08-8-18</i>		
Comment	: Rev Est:M 03.01.31 Added D2012-117 for D130-701-041 KJ/ RF Est Rev:N 06.04.05 Added level21 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TS0750W065	304 SQ Tube .75x.75x.065W
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Comment: Qty.: 45.7594 f(s)/Unit Total : 45.7594 f(s)

Pick:

3/4"x3/4" 304/316 SS tube *10.065 pt* *08.08.19*
0.063" wall

Batch: *M108786**SAD**08/08/20**①*

2.0	D31663	Basket Hoop
-----	--------	-------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

1	D3166-3	Basket Hoop	<i>40624</i>
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*SS**08/09/08**SAD 08/08/20**②*

3.0	D2506	Label Plate
-----	-------	-------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

1	D2506	Label Plate	<i>B39457</i>
---	-------	-------------	---------------

*SS**08/09/08*

4.0	D23271	Spacer Bushing
-----	--------	----------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

2	D2327-1	Bushing	<i>B40390</i>
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*SS**08/09/08*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/212/130 BASKET LID

Job Number: 41327A

Part Number: D2512

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D22321

Basket Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

✓ Qty Part Number Description Batch
2 D2232-1 Hinge plate B39454

LS 08/09/08

6.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

✓ Qty Part Number Description Batch
2 D2581 Mounting Bracket B40086

LS 08/09/08

7.0

M304EX07516F

Expanded Metal Flat SS



Comment: Qty.: 18.0000 sf(s)/Unit Total : 18.0000 sf(s)

Pick:

Qty Part Number Description Batch
18 sf M304EX0.75-16F Expanded Metal M108512
M108830

SAD 08/08/22 ①

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut 3/4" x 3/4" square tubing as per Dwg D2512

2-Cut (4) D2236 From D3166-3

3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305

SAD 08/08/20 ②

5-Weld as per Dwg D2512 using Welding Table and corner Jig Deburr as required

LS 08/09/10

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-09-10 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 18/08/2008 3:38:14 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/212/130 BASKET LID

Job Number: 41327A

Part Number: D2512

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

S 08/02/10 @

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

1ST COAT:

START TIME:

10:40 AM

OVEN TEMPERATURE:

400°F

FINISH TIME:

11:10 AM

2ND COAT:

START TIME:

11:30 AM

OVEN TEMPERATURE:

400°F

FINISH TIME:

12:00 PM

W 08-09-11

(X)

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4

Batch: *M108492*

FL 08/09/11

(P)

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 08/09/16 @

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

G-A

FL 08/09/16 @

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/16

Job Completion



MF 08-09-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

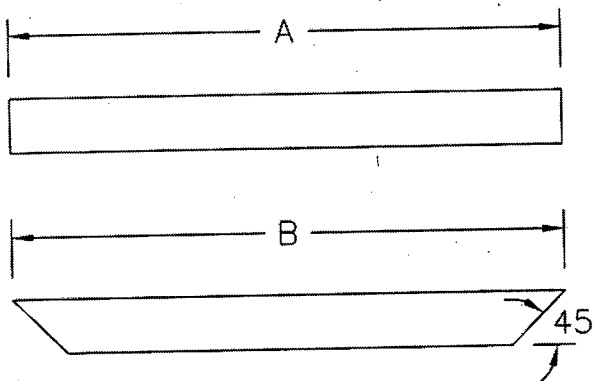


DESIGN BW	DRAWN BY UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2512	REV. D SHEET 1 OF 4
DATE 01.04.19		TITLE BASKET LID ASSEMBLY (350/212) NTS	
A	95.11.21	NEW ISSUE	
B	96.05.24	ADDED LATCH CHANNEL & LABEL PLATE	
C	99.07.06	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS, INCORP. DEO 9074	
D	01.04.19	CHANGE HINGE	
D1	# UP 03.01.20	ADD D2012-117 FOR D130-701-041	
D2	# UP 04.09.20	TACK WELD ANT-SKID AREA	

RELEASED
01.04.27 #

PARTS LIST FOR D2512 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2512-1	2	—	25.50	RIB
D2512-3	2	—	95.30	RIB
D2512-5	6	30.84	—	RIB
D2512-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRKT



UNDER REVIEW
08.02.85 PH
TUBING TO BE
CHANGED TO 0.065
WALL
PH 08.08.18
B

D2512-1/-3/-5/-7

CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST 0.065

MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.060 WALL SQUARE TUBING

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ALL DIMENSIONS ARE IN INCHES

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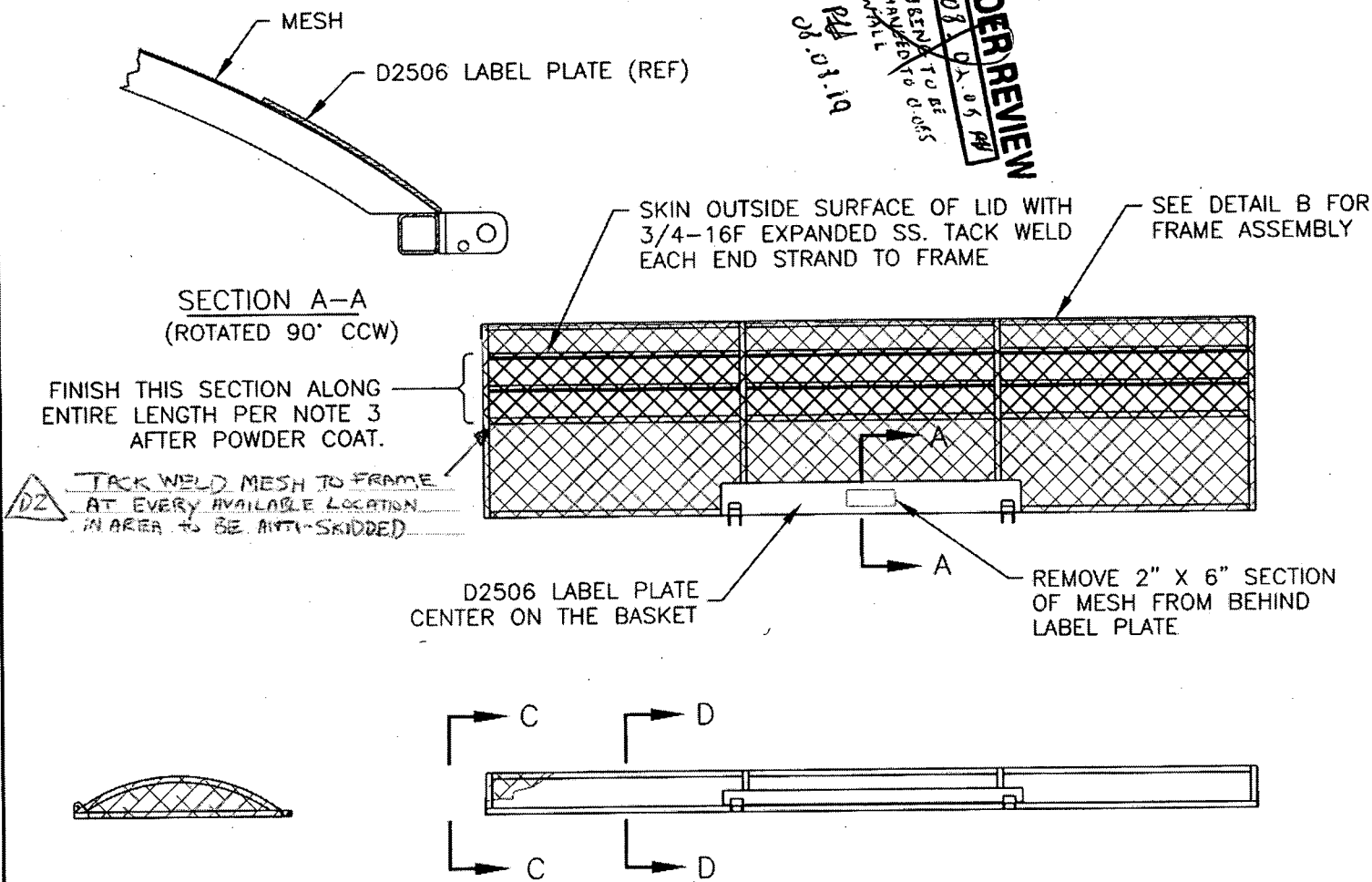
NO. 413271A

DART

QA COPY ISSUED

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BW	CS	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
<i>[Signature]</i>	<i>[Signature]</i>	D2512
DATE	TITLE	REV. D
01.04.19	BASKET LID ASSEMBLY (350/212)	SHEET 2 OF 4
		SCALE 1:20

UNDER REVIEW
08.01.19
TUBING TO BE CHANGED TO 0.065 WALL



D2512 BASKET LID ASSEMBLY

- 1) MESH MATERIAL: 3/4-16F EXPANDED SS
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) SPRAY PAINT BLACK INSIDE SURFACE
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

RELEASED
01.04.27

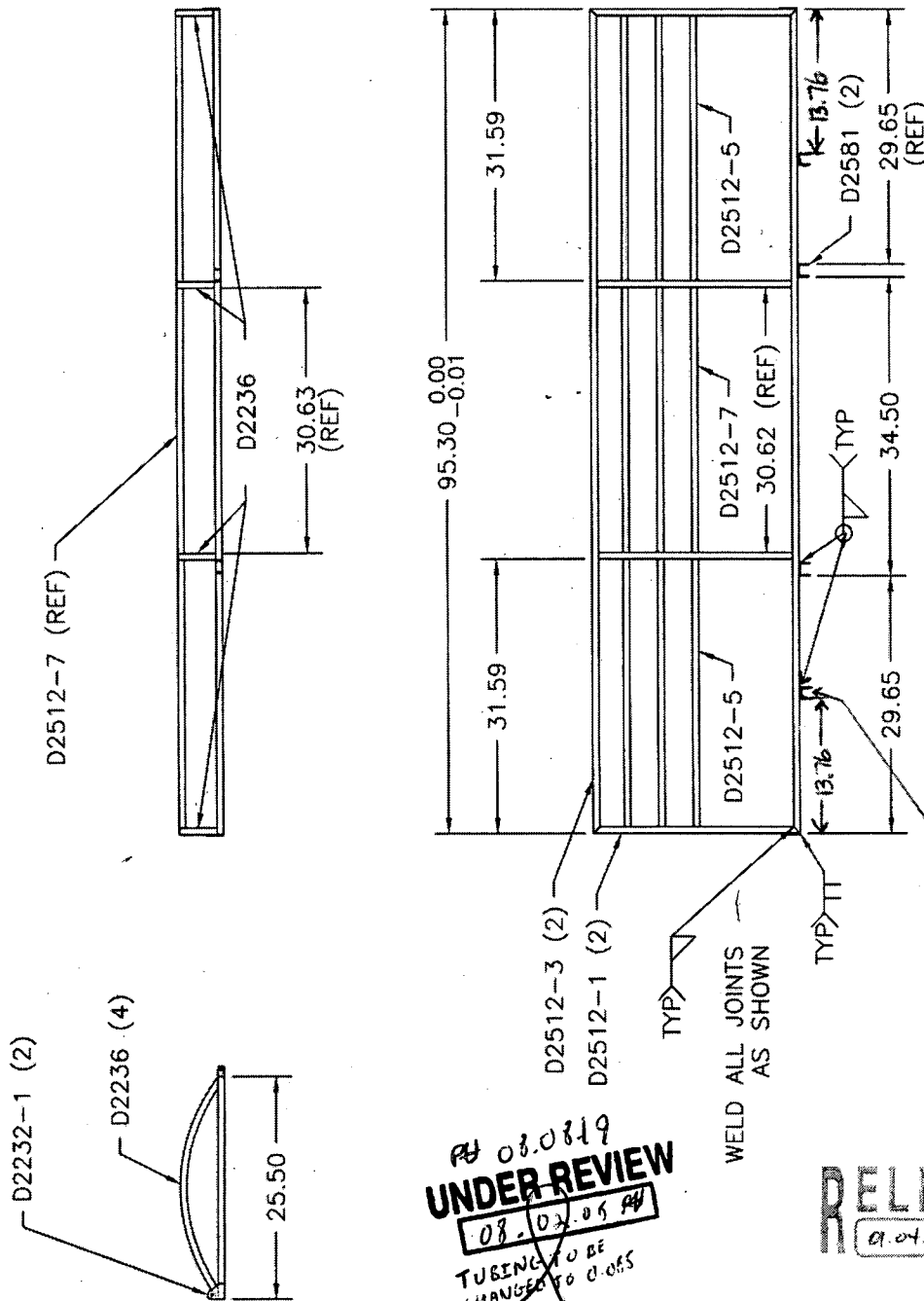
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WORK ORDER
NO. 443271A



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CHECKED #	APPROVED #	DRAWING NO. D2512	REV. D SHEET 3 OF 4
DATE 01.04.19	TITLE BASKET LID ASSEMBLY (350/212)		SCALE 1:20



DETAIL B
FRAMEWORK SHOWN FOR CLARITY
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

PH 08.0819
UNDER REVIEW
08.02.06 PH
TUBING TO BE
CHANGED TO 0.055
WALL

RELEASED
01.04.27

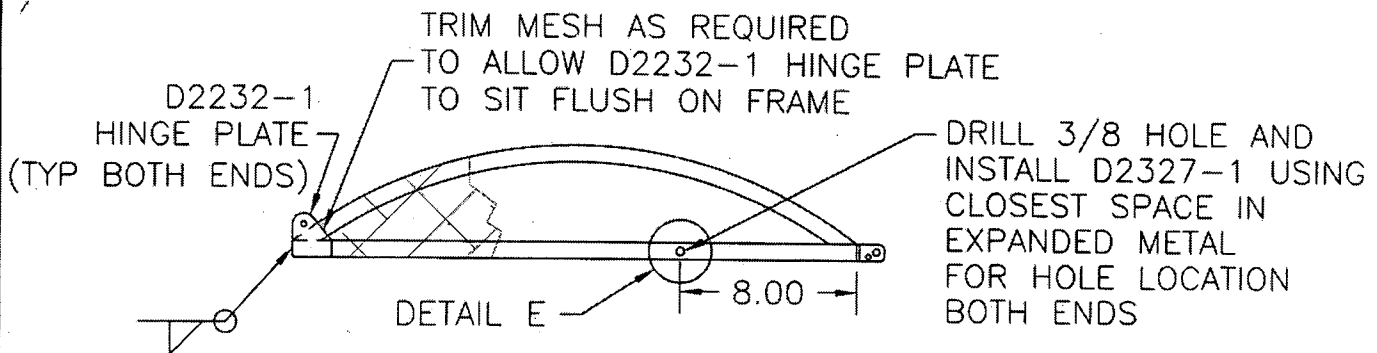
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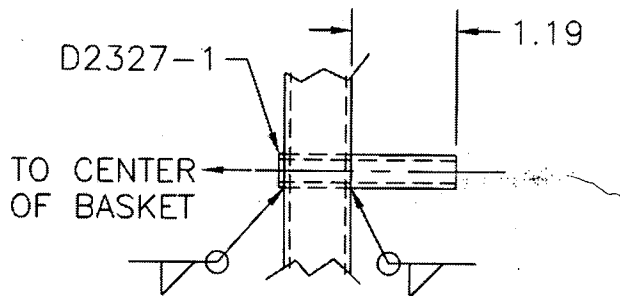
WITHOUT NOTICE
WORK ORDER
NO. 91322A



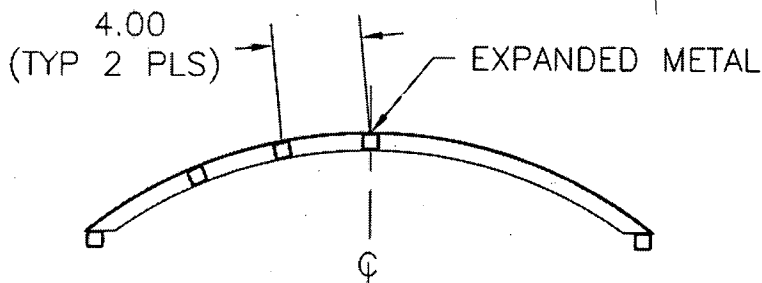
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CHECKED #	APPROVED #	DRAWING NO. D2512	REV. D SHEET 4 OF 4
DATE 01.04.19	TITLE BASKET LID ASSEMBLY (350/212)		SCALE 1:8



SECTION C-C SIMILIAR BOTH END RIBS



DETAIL E



SECTION D-D SAME BOTH CENTER RIBS

08.08.19
UNDER REVIEW
08.02.05 #
TUBING TO BE
CHANGED TO 0.065
WALL

RELEASED
01.04.27 #

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WORK ORDER

NO. 41327A

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Date: Monday, 18/08/2008 3:38:22 PM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	212 BASKET BASE ASS'Y RH
Job Number :	41327B		
Estimate Number :	11543		
P.O. Number :		Part Number :	D3053042 <i>PH 08.08.18</i>
This Issue :	18/08/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3053 UNDER REVIEW
First Issue :	//	Project Number :	
Previous Run :	40180B	Drawing Revision :	A
Written By :		Material :	
Checked & Approved By :	<i>JUL 08.8.18</i>	Due Date :	15/09/2008
Comment :	Est. C .02.09.04 M304EX0.75-16F was M750-16FXS-S/S K J/RF		

Qty: 1 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	M304TS0750W065	304 SQ Tube .75x.75x.065W
-----	----------------	---------------------------



Comment: Qty.: 45.5000 f(s)/Unit Total : 45.5000 f(s)
 304 SQ Tube .75x.75x.065W

1-Cut Rib from 3/4" x 3/4" x *0.065* wall 304/316 SS tubing. *PH 08.08.19*

Batch: *M108756*

2-Drill holes in D3053-3 as per dwg D3053

SAD 08/08/20 ①

2.0	D31661	Basket Hoop
-----	--------	-------------



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)
 Basket Hoop

Qty. 5 D3166-1

Batch: *40623*

SAD 08/08/20 ①

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------



Comment: LARGE FABRICATION RESOURCE 1

1-Cut 5 D2235-3 FROM D3166-1 using DT8365

2-Drill holes in three D2235-3 ribs as per dwg D3053 using DT8995

SAD 08/08/20 ①

4.0	D23273	Spacer Bushing
-----	--------	----------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Spacer Bushing

Pick:

Qty Part Number

Description

Batch

2 D2327-3

Bushing

B39560

SAD 08/09/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 18/08/2008 3:38:22 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212 BASKET BASE ASS'Y RH

Job Number: 41327B

Part Number: D3053042

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D22323

Basket Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Basket Hinge

Pick:

Qty Part Number Description
2 D2232-3 Hinge plate

Batch

B 39334

JS 08/09/03

6.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Mounting Bracket

Pick:

Qty Part Number
2 D2581

Description

Mounting Bracket

Batch

B 40086

JS 08/09/03

7.0

M304EX07516F

Expanded Metal Flat SS



Comment: Qty.: 50.4000 sf(s)/Unit Total : 50.4000 sf(s)

Expanded Metal Flat Stai

Pick:

Qty Part Number
48sq.ft M304EX0.75-16F

Description

Expanded Metal

Batch

M108830
M108424

SAN 08/08/22 (1)

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Remove all markings from material

2-Weld as per Dwg D3053 using Welding Table and corner Jig Deburr as required

JS 08/09/10

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-09-10 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 18/08/2008 3:38:22 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212 BASKET BASE ASS'Y RH

Job Number: 41327B

Part Number: D3053042

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

S 08/09/16

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Take Traveller D205-541-043 to KP

K/A

12.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

START TIME:

11:30AM

OVEN TEMPERATURE:

400°F

FINISH TIME:

12:00PM

1ST COAT = 10:40AM

OVEN TEMP = 400°F

FINISH

11:10AM

08-09-11

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08/09/16

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

6-A

08/09/16

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/16

Job Completion



MF 08-09-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

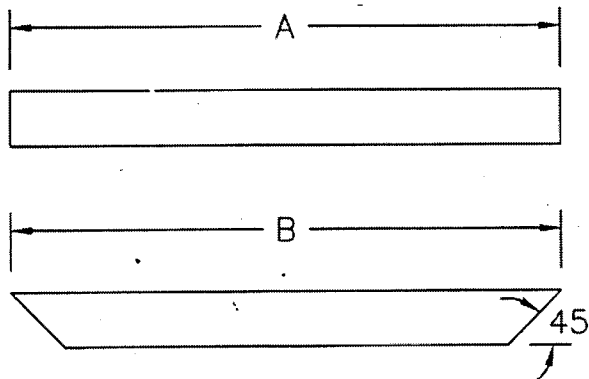


DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED A	APPROVED A	DRAWING NO. D3053	REV. A SHEET 1 OF 3
DATE 01.11.01		TITLE BASKET BASE ASSEMBLY (212)	SCALE NTS
A	01.11.01	NEW ISSUE	

RELEASED
01.12.20

PARTS LIST FOR D3053-041/D3053-042 BASKET BASE ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D3053-1	2	—	96.00	RIB
D3053-3	2	—	25.50	RIB
D3053-5	6	23.73	—	RIB
D3053-7	3	25.31	—	RIB
D3053-9	3	19.48	—	RIB
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MOUNTING BRKT
D2232-3	2	N/A	N/A	HINGE PLATE
D2235-3	5	N/A	N/A	RIB



UNDER REVIEW
08.02.05 RF
TUBING TO BE
CHANGED TO 0.065
WALL
RF
08.08.19

NOTES:

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) FRAME MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 RF 08.08.19 WALL SQUARE TUBING
- 3) MESH MATERIAL: 3/4-16F EXPANDED SS
- 4) WELD PER DART QSI 004
- 5) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES

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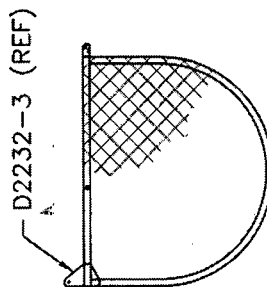
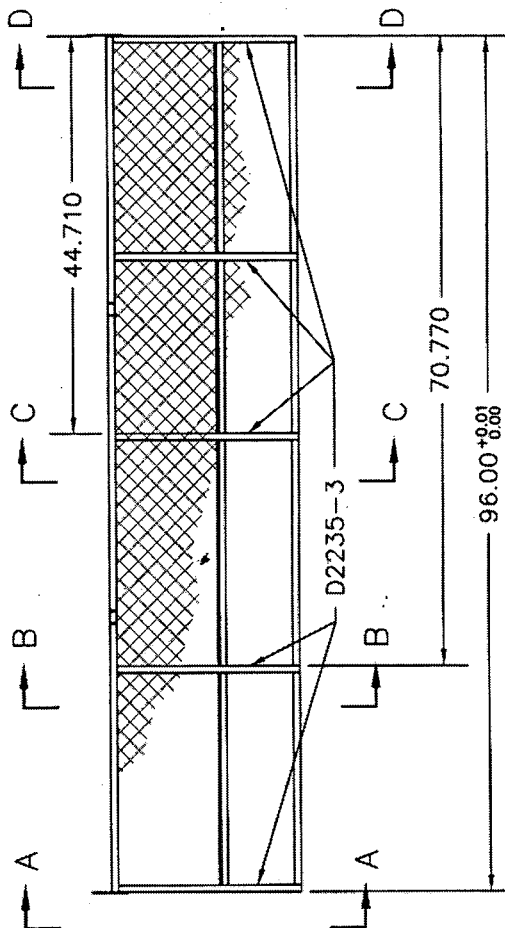
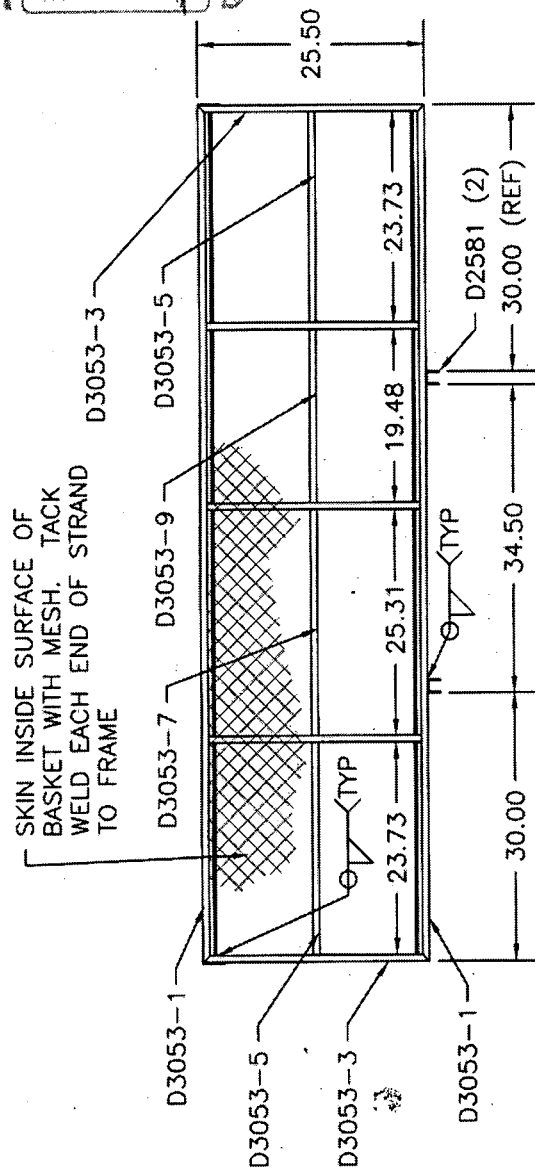
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NOTICE
WORK ORDER
NO. 41327B



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED A	APPROVED A	DRAWING NO. D3053	REV. A SHEET 2 OF 3
DATE 01.11.01		TITLE BASKET BASE ASSEMBLY (212)	SCALE 1:20

RELEASED
01.12.20



UNDER REVIEW
08.02.05
TUBING TO BE CHANGED TO 0.065 WALL
RF
08.02.19

D3053-042 BASKET BASE ASSEMBLY SHOWN
(D3053-041 BASKET BASE ASSEMBLY OPPOSITE)

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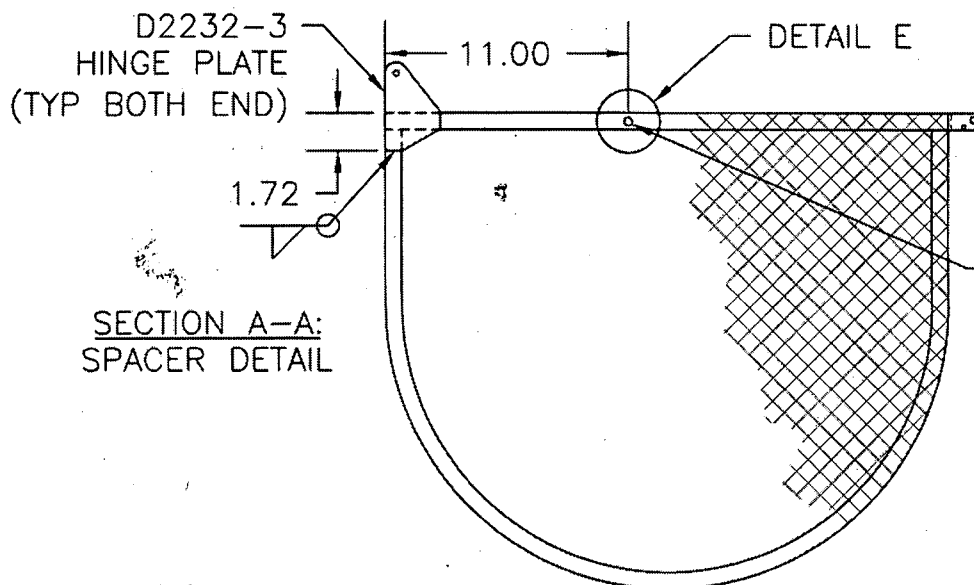
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WORK ORDER
NO. 41321B



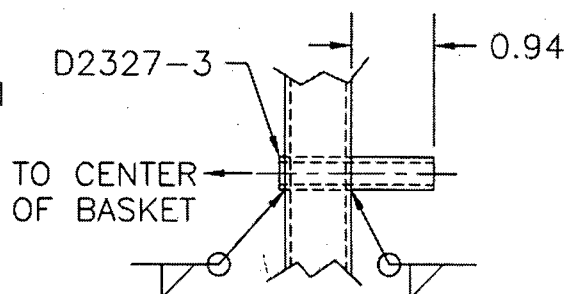
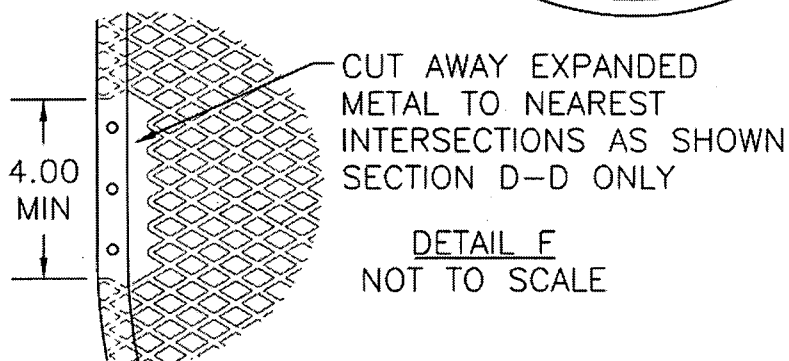
DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3053	REV. A SHEET 3 OF 3
DATE 01.11.01		TITLE BASKET BASE ASSEMBLY (212)	SCALE 1:8



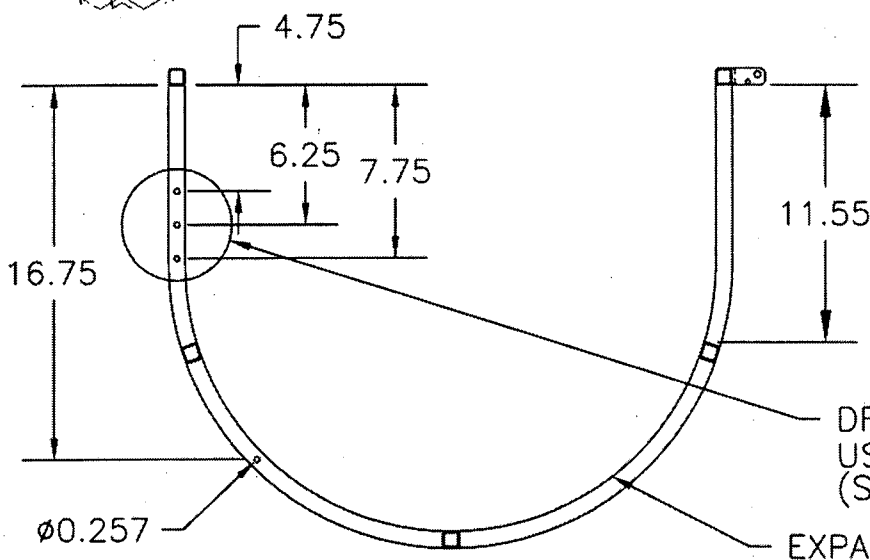
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01.12.20

SECTION A-A:
SPACER DETAIL

DRILL 3/8 HOLE
AND INSTALL
D2327-3 USING
CLOSEST SPACE IN
EXPANDED METAL
FOR HOLE LOCATION
BOTH ENDS



DETAIL E



SECTION B-B,
SECTION C-C AND
SECTION D-D:
RIB DETAIL

DRILL 0.257 DIA HOLES
USE DRILL JIG T2489DJ
(SEE DETAIL F)

UNDER REVIEW
08.02.05 PH
TUBING TO BE
CHANGED TO 0.065
WALL
RA 07.08.19

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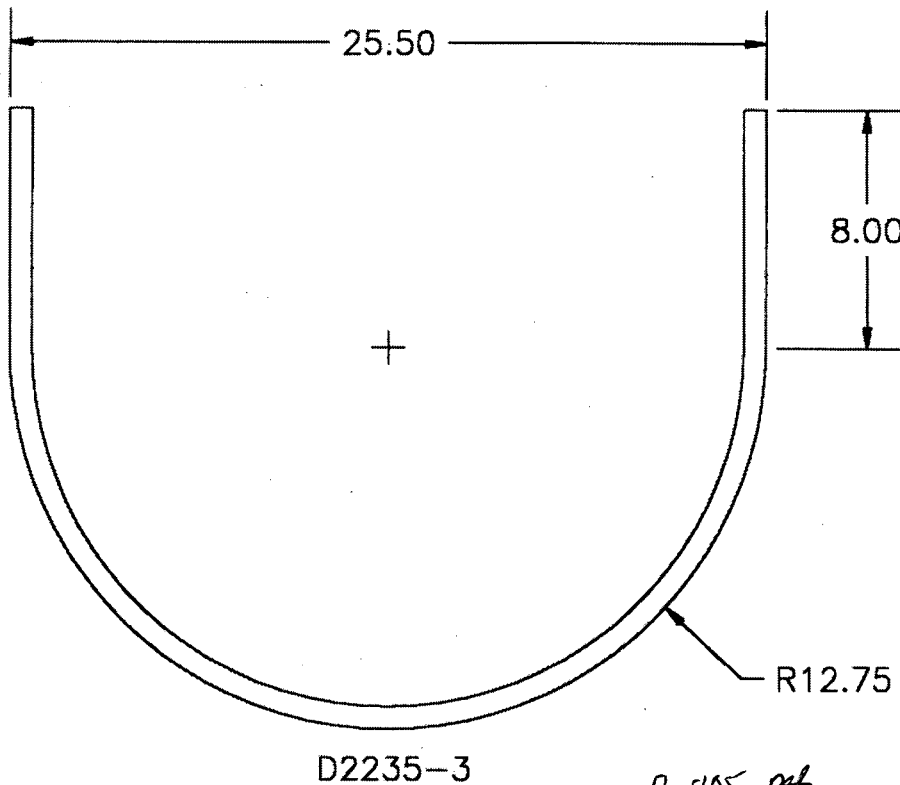
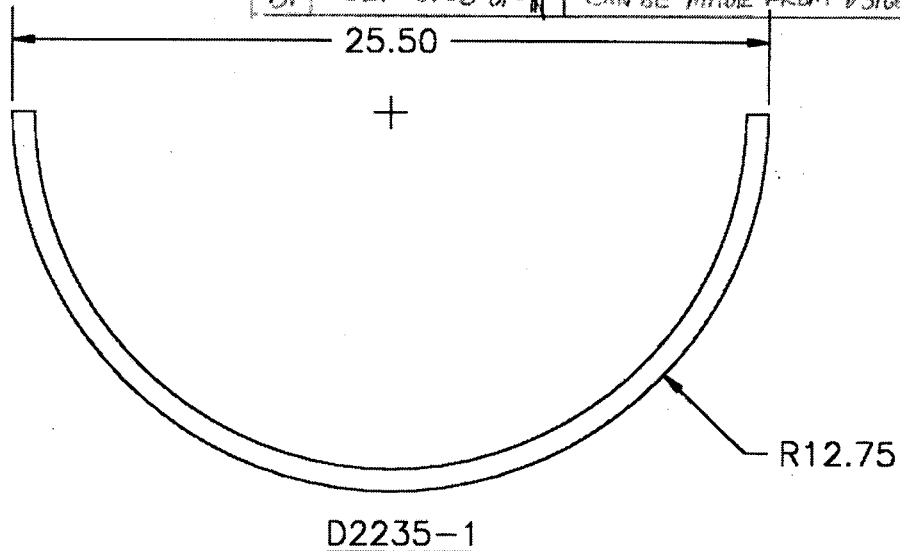
WITHOUT NOTICE
WORK ORDER


NO. 41327B



DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	B WILLIAMS	DRAWING NO.	REV. B
CHECKED	APPROVED	D2235	SHEET 1 OF 1
DATE	TITLE		SCALE
94:12:16	BASKET RIBS		
BI	02.08.06	CAN BE MADE FROM D3166-1	

RELEASED
R 960507



D2235-3
CAN BE MADE FROM D3166-1 
MATERIAL: 304/316 SS, 3/4 X 3/4 X 0.063 WALL SQR.

0.065 *pt*
0.063 *pt*

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